



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2906	REV. A SHEET 1 OF 3
DATE 04.06.22		TITLE AH-1 (209) SKIDTUBE ASSEMBLY	SCALE NTS
A	04.06.22	NEW ISSUE	

QTY -041	QTY -043	Part Number	Description
X		D2906-041	SKIDTUBE ASSEMBLY
	X	D2906-043	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2577-1	WEARSHOE
1	1	D2577-3	WEARSHOE
2	1	D2577-5	WEARSHOE
22	19	D2579	CROSS BOLT SPACER
12	14	D2594-1	PLUG
12	14	D2594-3	O-RING
2	2	D2855	AFT CAP
1		D2926-1	WEB
	1	D2926-3	WEB
50	44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
50	44	AN3-4A	BOLT
4	4	AN3-5A	BOLT
54	48	AN960JD10L	WASHER

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2926-1/-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 6) USE DART DRILL TEMPLATE DT2906-041T1 (D2906-041) OR DT2906-043T1 (D2906-043) TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241/291.
- 7) WELDING TO BE DONE PER DART QSI 004.
- 8) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3 WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 9) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).

**UNDER REVIEW**

06.11.08 PH  
REMOVE HOLE ON  
AFT BENT PORTION  
ON D2906-041

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RELEASED  
84-06-25

Technical drawing of a circular cross-section of a shaft. The diameter is 7.000. The distance from the center to the top hole is 5.250. The distance from the center to the bottom hole is 1.750.

SEAL WITH  
SIKAFLEX-241/291

DETAIL B  
SCALE 1:4

0.40

DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

AN3-5A BOLT (1)  
AN960J10L WASHER (1)  
(2 PLACES)

D2855 CAP

SECTION C-C  
SCALE 1:4

D2926-1 WEB (REF)

57-1032-130 (REF)

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø.437 X 1.00 DEEP

6

[illegible]

06.11.90

06.11.08 P44

Technical drawing of a bent pipe with dimensions and callouts. The drawing shows a side view of a pipe with a bend. Key dimensions and callouts include:

- Callout 4:** Points to the top of the pipe bend.
- Callout 5:** Points to the bottom of the pipe bend.
- Dimensions:**
  - 116.0 (REF): Horizontal distance from the start of the bend to the end of the bend.
  - 6.02: Vertical distance from the horizontal centerline to the top of the bend.
  - 1.4: Vertical distance from the horizontal centerline to the bottom of the bend.
  - 1.0: Vertical distance from the horizontal centerline to the top of the bend.
  - 13.4 (REF): Vertical distance from the horizontal centerline to the bottom of the bend.
  - 12.9: Horizontal distance from the start of the bend to the tangent point.
  - 25.7 (REF): Horizontal distance from the end of the bend to the tangent point.
  - 4.00: Horizontal distance from the tangent point to the end of the bend.
  - 2.0: Horizontal distance from the tangent point to the end of the bend.
- Text:**
  - DISTANCE BETWEEN HOLE AND TANGENT POINT: Two labels indicating the horizontal distance from the hole to the tangent point.
  - DISTANCE BETWEEN HOLE AND TANGENT POINT: Two labels indicating the horizontal distance from the hole to the tangent point.

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04.06.25

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

REFER TO DETAIL B

1.5

0.5

C

P

D2577-1 WEARSHOE

D2577-5 WEARSHOE

MAKE FROM D2577-5 WEARSHOE

18.00

D2577-3 WEARSHOE

9






AN3-4A BOLT (1)

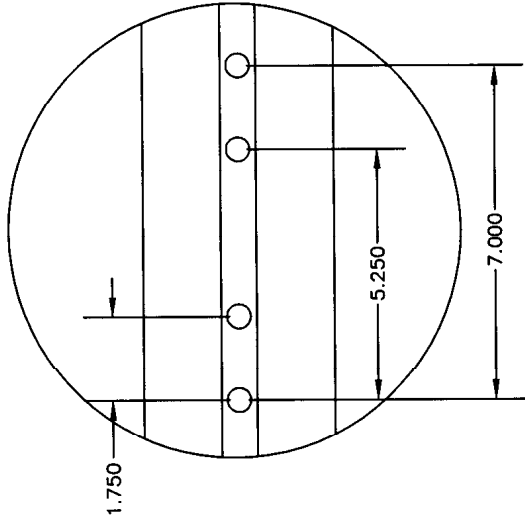
AN96QID10L WASHER (1) (50 PLACES)

6

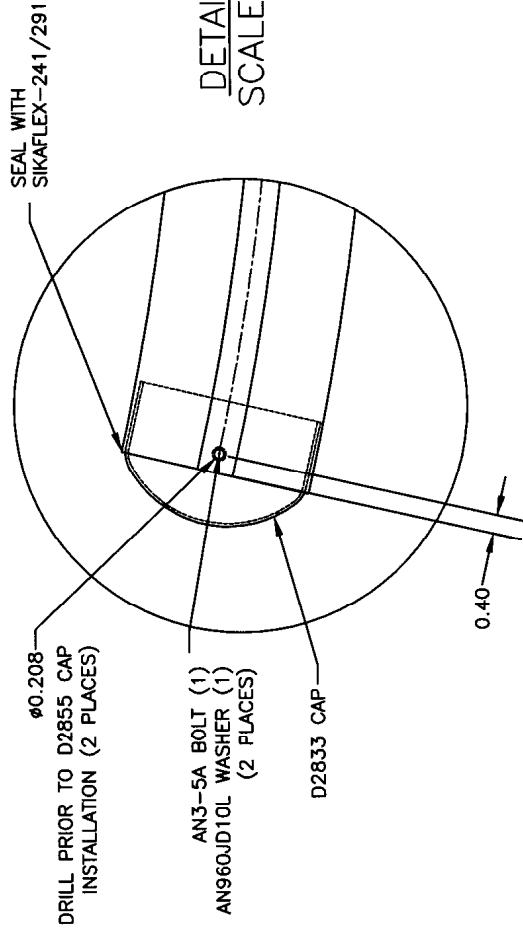
REFER TO DETAIL B

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		CHECKED 	APPROVED 	DRAWING NO. D2906	REV. A SHEET 2 OF 3
		DATE 04.06.22	TITLE AH-1 (209) SKIDTUBE ASSEMBLY		SCALE 1:24

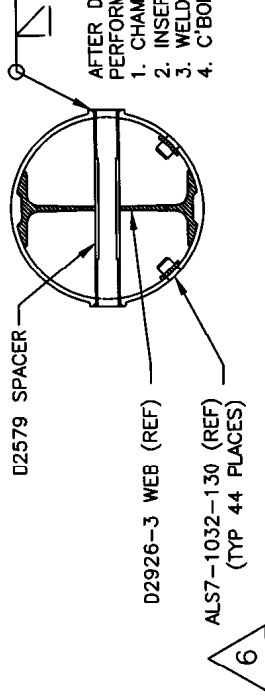


DETAIL A  
SCALE 1:4



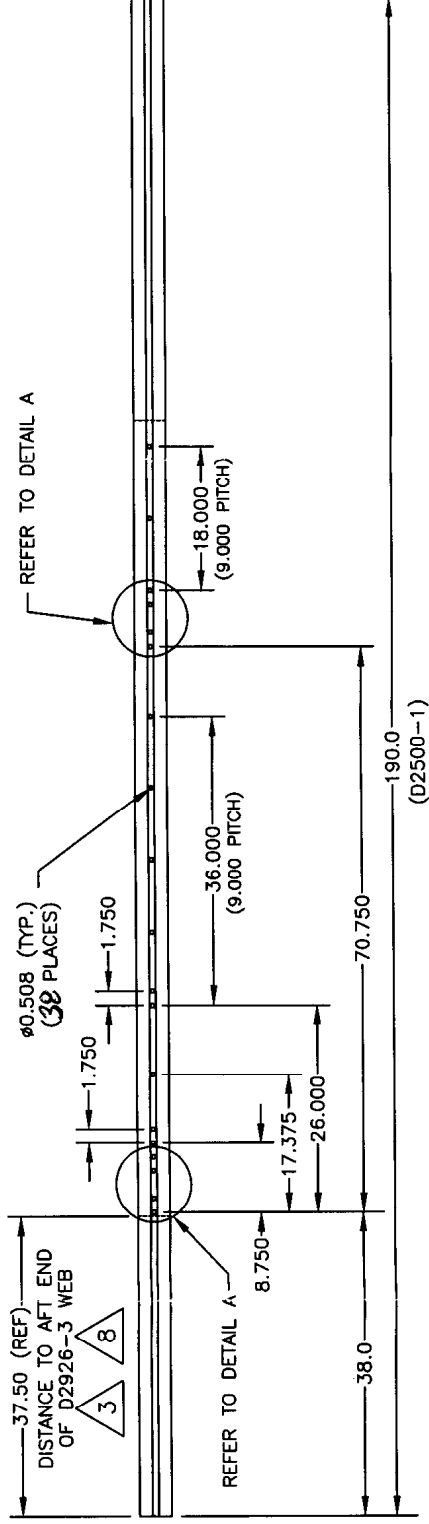
DETAIL B  
SCALE 1:4

SECTION C-C  
SCALE 1:4

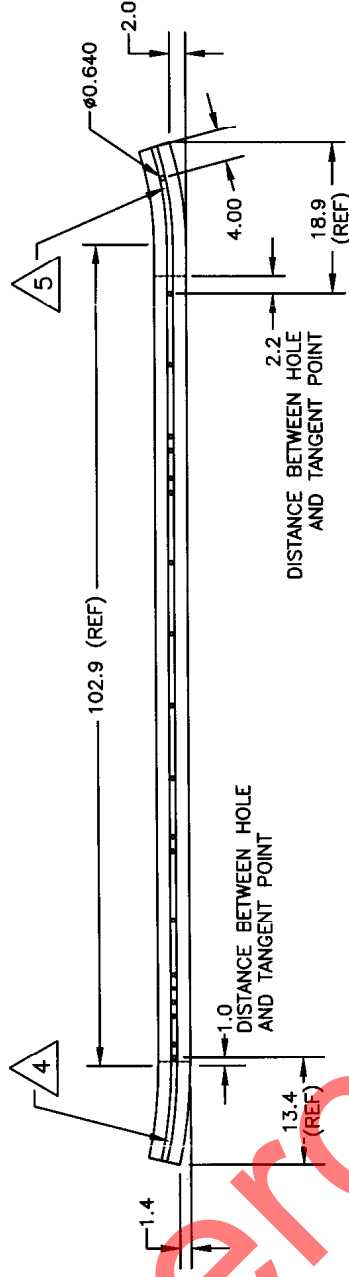


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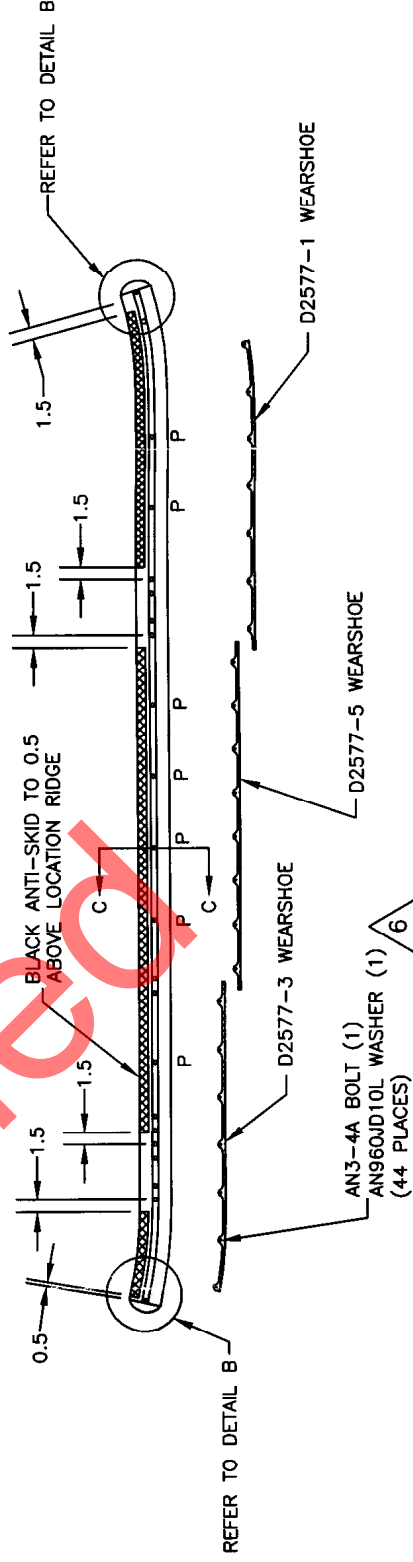
# D2906-3 DRILLING DETAIL



# D2906-043 BENDING AND CUTTING DETAIL



# D2906-043 ASSEMBLY DETAIL



UNDER REVIEW

05.11.08 PH

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04.06.25



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HAWKESBURY, ONTARIO, CANADA

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D2906

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DESIGN  
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REV. A  
SHEET 3 OF 3

TITLE  
AH-1 (209) SKIDTUBE ASSEMBLY

SCALE  
1:24